Work Order ID 111190

January-09-14 12:45:06 PM

111190

Rev E 14/01/24

PRELIMINARY ISSUE

Item ID: D4635-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Fwd Ceiling Panel, LH **Stop** *NS2*

Start Date: 09/01/2014 **Start Qty:** 1.00 *1*

Required Date: 24/01/2014 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** MH **Date:** 14-01-09 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D4635	**Revision Nbr** ~~PD2~~ Rev E DAS 27 0.89	per ECN 14-509							
100	HAND FINISHING THERMOFORMING	0.00							
100						x1			MH 14/01/13
Thermoform	**Memo**	0.00							
Thermoforming Machine	Cut Blanks								
105		0.00							
105	Dry Material					x1			MH 14/01/13
HandThermo	**Memo**	0.00							
Hand Finishing Thermoforming	Dry Sheet as per QSI022 KYDEX								

Temp: 245° F

Time IN: 5:00 pm 14/01/12

Time OUT: 6:00 am 14/01/13

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D4635-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Fwd Ceiling Panel, LH
Start Date: 09/01/2014 **Start Qty:** 1.00 *1*
Required Date: 24/01/2014 **Req'd Qty:** 1.00 *1*
Reference:
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
110	THERMOFORMING MACHINE					x1			DL 14/01/13
Thermoform	**Memo**	0.00							
Thermoforming Machine	Thermoform as per Dwg. D4635-1 and Folio FTA147								
	Dwg. Rev. PE1								
	Folio Rev. C								
	Visually inspect for proper formation and texture								
130		0.00							
130	HAND FINISHING THERMOFORMING					x1			DL 14/01/18
Thermoform	**Memo**	0.00							
Thermoforming Machine	Trim to Finished Dimensions								
140	QC2- Inspect parts off machine FAI/FAIB	0.00							
140						x1			DL 14/01/18
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Set-up
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☐ Other

Item ID: D4635-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Fwd Ceiling Panel, LH
Start Date: 09/01/2014 **Start Qty:** 1.00 *1*
Required Date: 24/01/2014 **Req'd Qty:** 1.00 *1*
Reference:
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00				1			
150 QC Quality Control	**Memo**	0.00				Inspect as per Dwg PE1			
160	Packaging	0.00							
160 Packaging Packaging	**Memo**	0.00				MLS			
170	QC21- Final Inspection - Work Order Release	0.00							
170 QC Quality Control	**Memo**	0.00				MLS 14-01-23			

DAS 27 9-89 14/01/24

Thermoforming

14-01-24

POSITIVE RECALL
EFFECTIVE 14/01/24 AUTH
RELEASED S DATE 14/01/24

Release Dwg Rev E

DAS 27 9-89 14/1/23

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

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Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
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Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other _____

Picklist Print

January-09-14 12:45:11 PM

1

Work Order ID: 111190 *111190*

Parent Item: D4635-1 *D4635-1*

Parent Item Name: Fwd Ceiling Panel, LH

Start Date: 09/01/2014 **Required Date:** 24/01/2014

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev. A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev. B Dwg. Update 12/11/08 DL IPP Rev. C Dwg Update 13/07/09 DL IPP Rev D Dwg Update, Material Change 13/12/18 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	1,861.260	14.9	15			

MLEXS.093-F6006-07

GE PLASTICS LEXAN SHEET

**

OK

14/01/27

Location	Loc Qty	Loc Code
MAT023	1861.26	
114459	229.26	
123105	38	
124501	1594	

15 sq ft.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

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Doc/Data	☐									
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Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

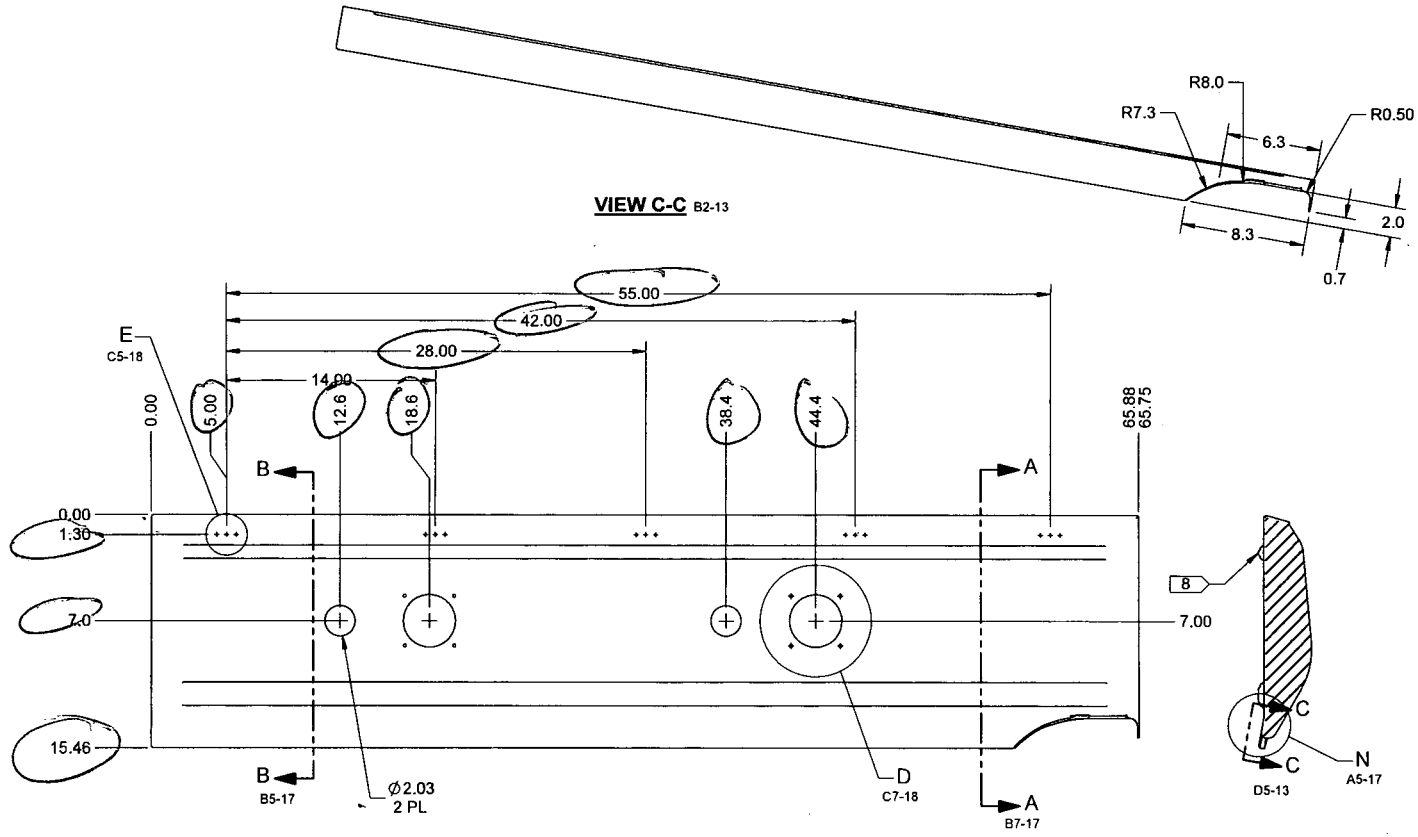
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☐ Other

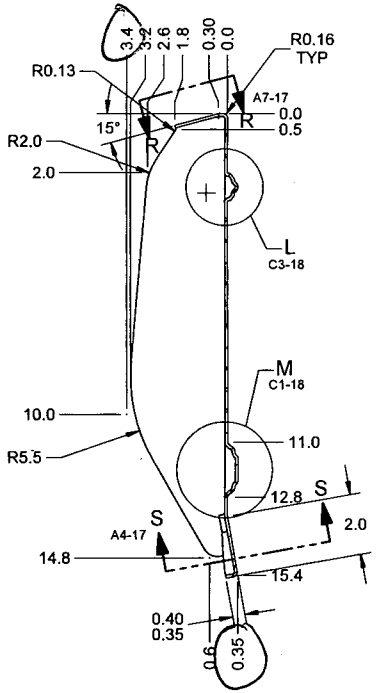


NOTES:
1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 4.39 lbs
8) TEXTURE ON THIS SIDE
9) TRIM D4635-1 PER TOOL DT9839
10) THERMOFORM D4635-1 PER QSI 022 USING DT9847 TOOL
MIN. THICKNESS AFTER FORMING:
SHADED AREA = 0.040
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

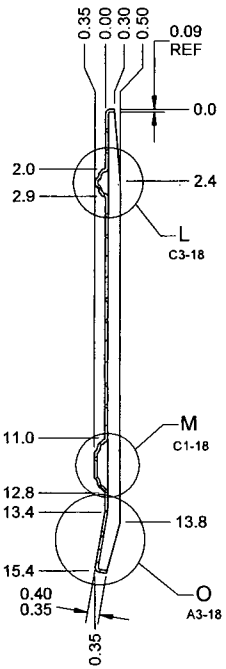
D4635-1 LH, FWD CEILING PANEL

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	JC	DRAWING NO. D4635 REV. PE1
MFG. APPR.		SHEET 13 OF 18
APPROVED		TITLE OUTBOARD CEILING PANELS SCALE NTS
DE APPR.		
DATE	14.01.09	

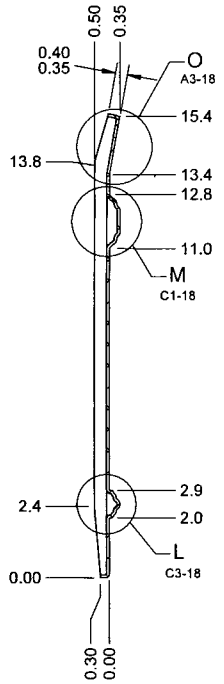
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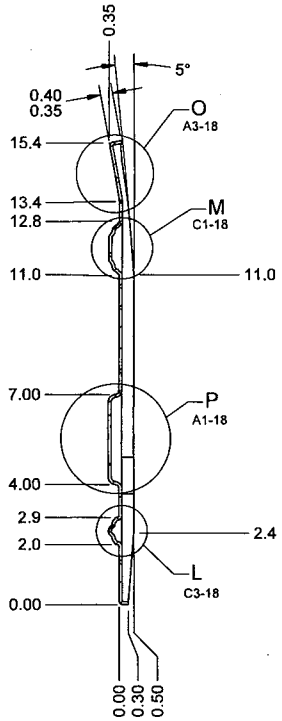
SECTION A-A
SECTION A'-A' OPPOSITE B3-13 B3-14
SCALE 2X



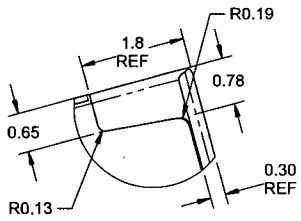
SECTION B-B B7-13 B7-14
SCALE 2X



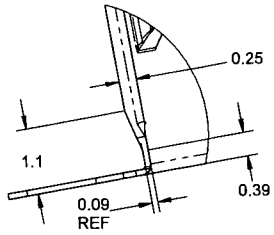
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SCALE 2X



SECTION K-K C6-16
SCALE 2X

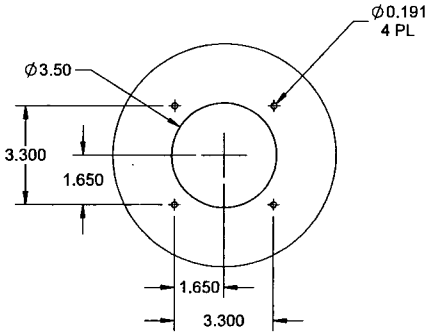


AUXILIARY VIEW R-R D7-17
SECTION R'-R' OPPOSITE
SCALE 2X

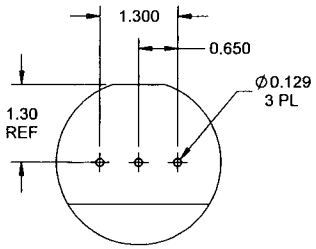


AUXILIARY VIEW S-S B7-17
SECTION S'-S' OPPOSITE
SCALE 2X

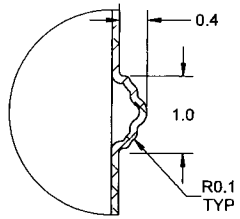
DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	BC	DRAWING NO. D4635	REV. PE1 SHEET 17 OF 18
MFG. APPR.			
APPROVED		TITLE OUTBOARD CEILING PANELS	SCALE NTS
DE APPR.			
DATE 14.01.09		COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



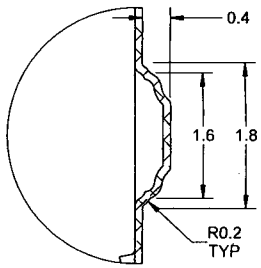
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SCALE 2X



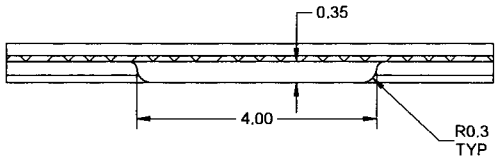
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SCALE 4X



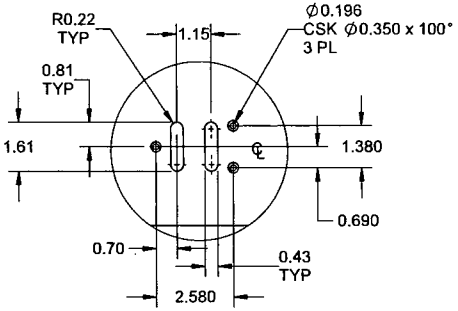
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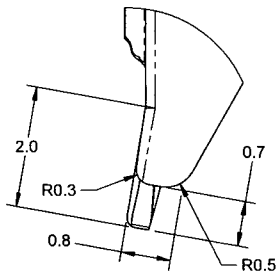
DETAIL M C2-17 C3-17 C5-17 C7-17
SCALE 1.5X



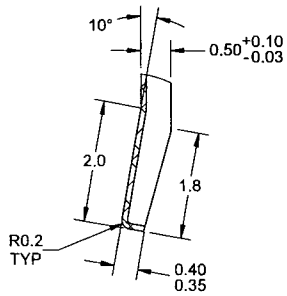
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SCALE 4X



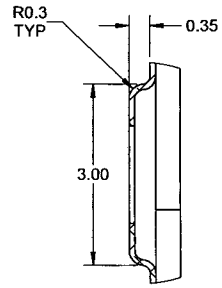
DETAIL Q C5-16
SCALE 2X



DETAIL N B2-13
SCALE 2X



DETAIL O D2-17 D3-17 B5-17
SCALE 2X



DETAIL P C2-17
SCALE 4X

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. REV. PE1
CHECKED	BC	D4635 SHEET 18 OF 18
MFG. APPR.		TITLE SCALE
APPROVED		OUTBOARD CEILING PANELS NTS
DE APPR.		
DATE	14.01.09	

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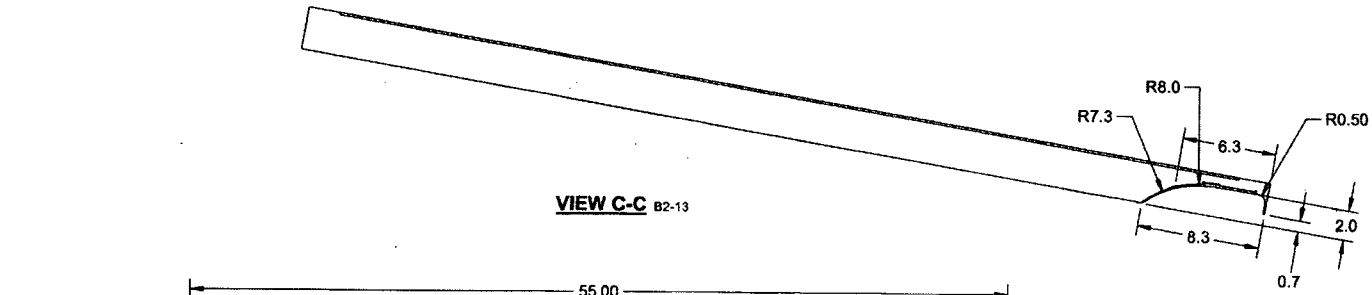
DART AEROSPACE LTD

Description:	PANEL	Work Order:	111190
Inspection Drawing:	D4635	Rev:	DE1
Part Number:	D4635-1		

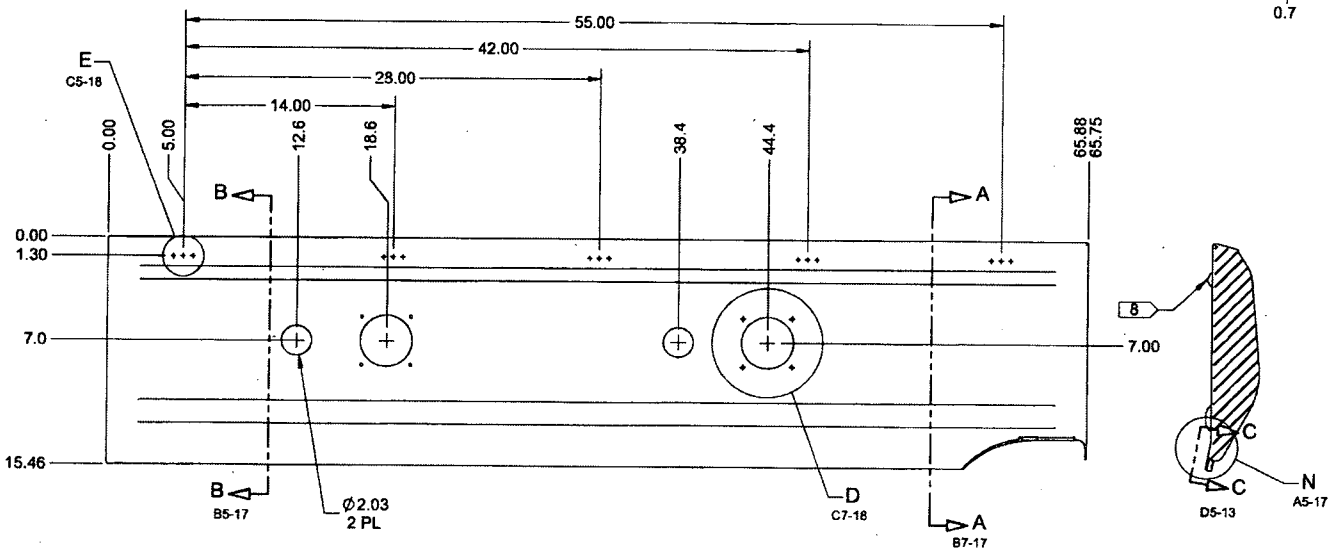
INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.30"	~~+/- .030~~	0.33"	✓		Vern DL-02	
0.35"	.35-.40	0.40"	✓		"	
0.50"	+/- .030	0.53"	✓		"	
Ø 3.50"		3.52"	✓		"	
Ø 2.03"		2.004"	✓		"	
Ø 0.191		0.190"	✓		"	
Ø 0.129"		0.129"	✓		"	
55.00	± .030	55.00	✓			
42.00	± .030	42.00	✓			
28.00	± .030	28.00	✓			
18.60	± .030	18.625	✓			
12.60	± .030	12.625	✓			
5.00	± .030	5.00	✓			
1.30	± .030	1.80	✓			
7.0	± .030	7.0	✓			
15.46	± .030	15.46	✓			
3.4	± .030	3.4	✓			
.35	± .005 ± .001	.35	✓			

Measured by:	Checked By: AS 27 ~~9~~ 89	QC inspector:	Engineering Approval (*if necessary*):
Date 14/01/18	Date 14/1/21	Date	Date



VIEW C-C B2-13

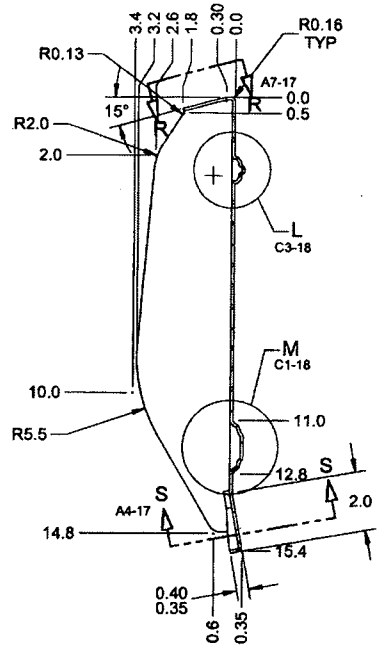


NOTES:
1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 4.39 lbs
8) TEXTURE ON THIS SIDE
9) TRIM D4635-1 PER TOOL DT9839
10) THERMOFORM D4635-1 PER QSI 022 USING DT9847 TOOL
MIN. THICKNESS AFTER FORMING:
SHADED AREA = 0.040
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

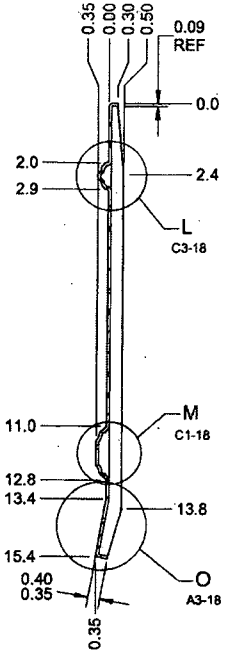
D4635-1 LH, FWD CEILING PANEL

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. D4635 REV. E
CHECKED		SHEET 13 OF 18
MFG. APPR.		TITLE OUTBOARD CEILING PANELS SCALE NTS
APPROVED		
DE APPR.		
DATE	14.01.09	

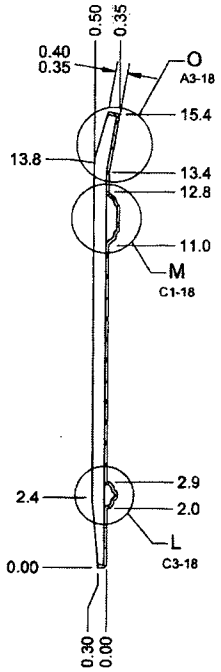
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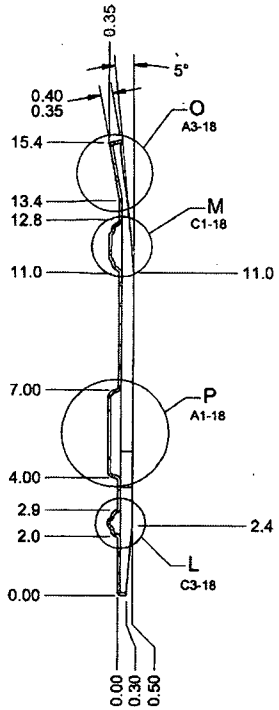
SECTION A-A
SECTION A'-A' OPPOSITE B3-13 B3-14
SCALE 2X



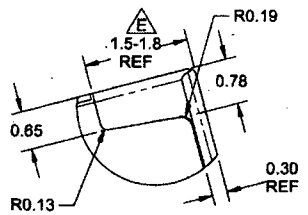
SECTION B-B B7-13 B7-14
SCALE 2X



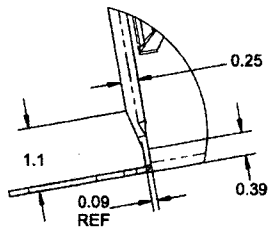
SECTION G-G B4-15 B4-16
SCALE 2X



SECTION K-K C6-16
SCALE 2X



AUXILIARY VIEW R-R
SECTION R'-R' OPPOSITE D7-17
SCALE 2X

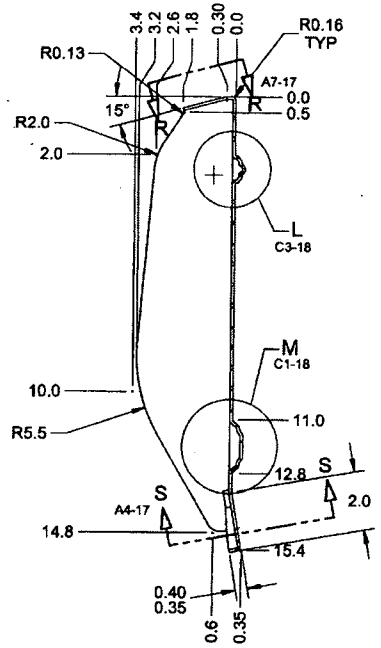


AUXILIARY VIEW S-S
SECTION S'-S' OPPOSITE B7-17
SCALE 2X

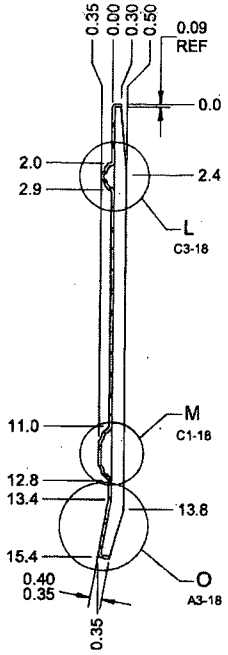
DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO. REV. E
MFG. APPR.		D4635 SHEET 17 OF 18
APPROVED		TITLE SCALE
DE APPR.		OUTBOARD CEILING PANELS NTS
DATE	14.01.09	

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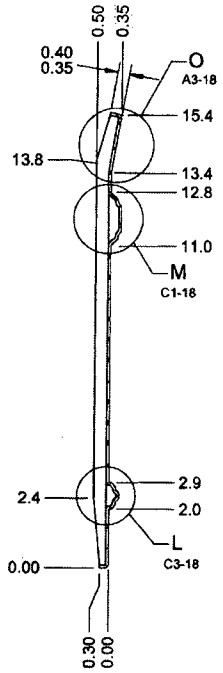




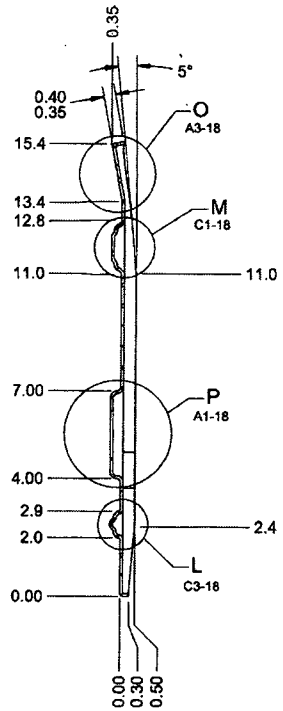
SECTION A-A
SECTION A'-A' OPPOSITE B3-13 B3-14
SCALE 2X



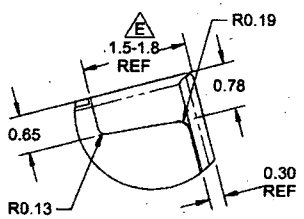
SECTION B-B B7-13 B7-14
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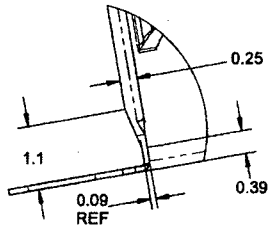
SECTION G-G B4-15 B4-16
SCALE 2X



SECTION K-K C6-16
SCALE 2X



AUXILIARY VIEW R-R
SECTION R'-R' OPPOSITE D7-17
SCALE 2X



AUXILIARY VIEW S-S
SECTION S'-S' OPPOSITE B7-17
SCALE 2X

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	BC	DRAWING NO. D4635 REV. E SHEET 17 OF 18
MFG. APPR.		
APPROVED		TITLE OUTBOARD CEILING PANELS SCALE NTS
DE APPR.		
DATE 14.01.09		

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